

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009322**Date Inspected:** 15-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Ma Yun, Li Hong Fei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower/OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY #10

This QA Inspector randomly observed the following work in progress.

This QA observed ZPMC welder 040338 performing buttering with the help of FCAW welding process of the plate P1232. ZPMC QC is identified as Ma Yun. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair.

FCAW welding process of weld joint 4B located on PCMK NSD1-SPSA3-56. Welder is identified as 040533ZPMC QC is identified as Ma Yun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-F.

FCAW welding process of weld joint 01 located on PCMK SSD1-FCSA4-1C/C. Welder is identified as 040343ZPMC QC is identified as Jian Xi Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

BAY#11

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This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 05 located on PCMK ESD1-FASA3-2A/F. Welder is identified as 070254 ZPMC QC is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

TRIAL ASSEMBLY YARD

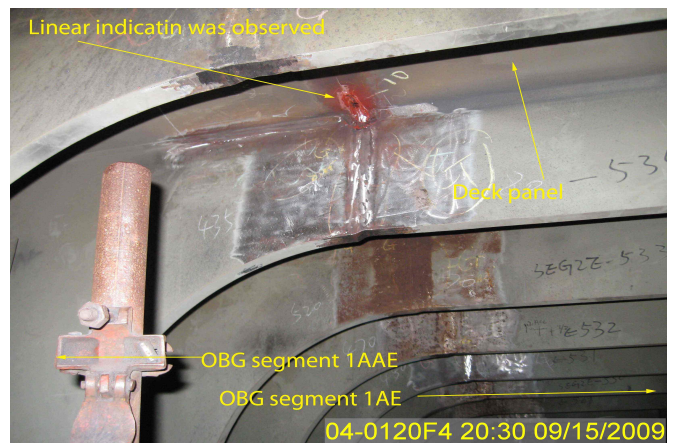
This QA Inspector randomly observed the following work in progress.

OBG SEGMENT-1AAE-1AE

FCAW welding process of weld joint 003 located on PCMK OBE1A. Welder is identified as 045280 ZPMC QC is identified as Zhong Hai Tao. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-1G (1F) Repair.

During the random visual inspection this QA Inspector noted that ZPMC found one transverse linear indication at the excavation (gouged) area of deck panel splice weld joint between OBG segment 1AAE-1AE, this linear indication located approximately 2815 mm from 'Y' axis (Bike path side). I also noted that after found the indication ZPMC performed grinding to remove the indication, and ZPMC did not perform Magnetic particle inspection of the grind area. This QA performed Magnetic particle inspection of the excavated area and found the linear indication is still there. This linear indication majored approximately 15 to 20mm in length. For this issue informed to task leader and other supervisor. For additional information see attached photos.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
